

Tuesday, 3/20/2007 1:53:38 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 31382
 Estimate Number : 12597
 P.O. Number : *N/A*
 This Issue : 3/20/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL /MED FAB
 Previous Run : 31229
 Written By :
 Checked & Approved By : *407.03.20*
 Comment : Est A 06.12.01 New Issue EC

Drawing Name : HOOK
 Part Number : D30465
 Drawing Number : D3046 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : *N/A*
 Due Date : 4/15/2007

Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B0375X1000 17-4 SS Bar 3/8 x 1"



Comment: Qty.: 0.1397 f(s)/Unit Total : 2.7930 f(s)
 17-4PH Stainless Steel Bar 3/8" x1.00"
 Batch: *M104012*

and 07/04/11

60

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 1.600" long

and 07/04/11

60

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA659 Rev: *AA* & Dwg D3046 Rev: *B*

2-Deburr per dwg D3046

SD/and 07/04/11

60

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD/and 07/04/11

60

5.0 QC8 SECOND CHECK



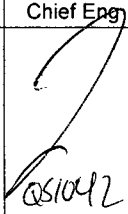

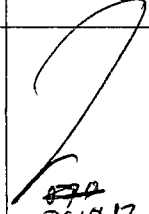
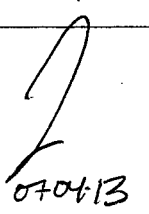
Comment: SECOND CHECK

SG 07-04-11

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 07/04/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/13	3.0	2 parts moved while machining	 QS1042	change end mill scrap and replace	JA 07/04/13	 07/04/16	 QS1042	 07/04/13

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:53:38 PM
User: Kim Johnston

Process Sheet

Customer: .CU-DAR001 Dart Helicopters Services

Drawing Name: HOOK

Job Number: 31382

Part Number: D30465

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 7/04/12 (GO)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(GO)

Comment: FINAL INSPECTION/W/O RELEASE

ED07104/16

Job Completion



u 07-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31382
Description: Hook		Part Number:	D3046-5
Inspection Dwg: D3046 Rev: B			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by:	<i>gm</i>	Audited by:	<i>BC</i>	Prototype Approval:	N/A
Date:	07/04/11	Date:	07.04.11	Date:	N/A

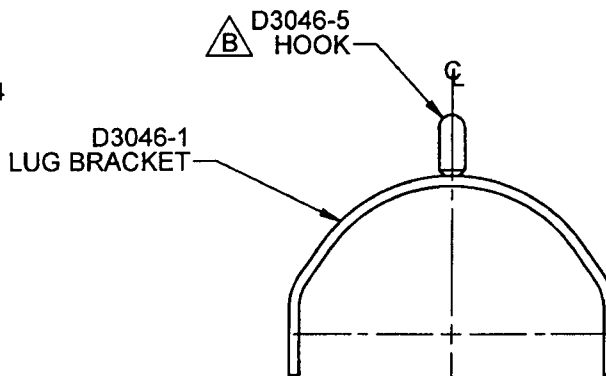
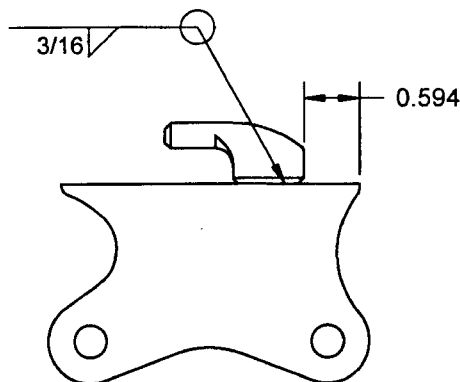
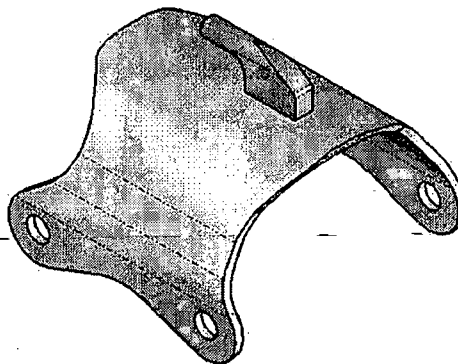
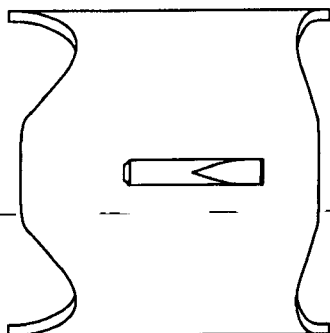
Rev	Date	Change	Revised by	Approved
A	07.03.13	New Issue	KJ/JLM	



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 1 OF 3
DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY	SCALE 1:2
REV A	DATE 01.08.23	DESCRIPTION NEW ISSUE	
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL	

RELEASED

06.11.13 #



D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK



NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI) CONTROLLED COPY
POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING

CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

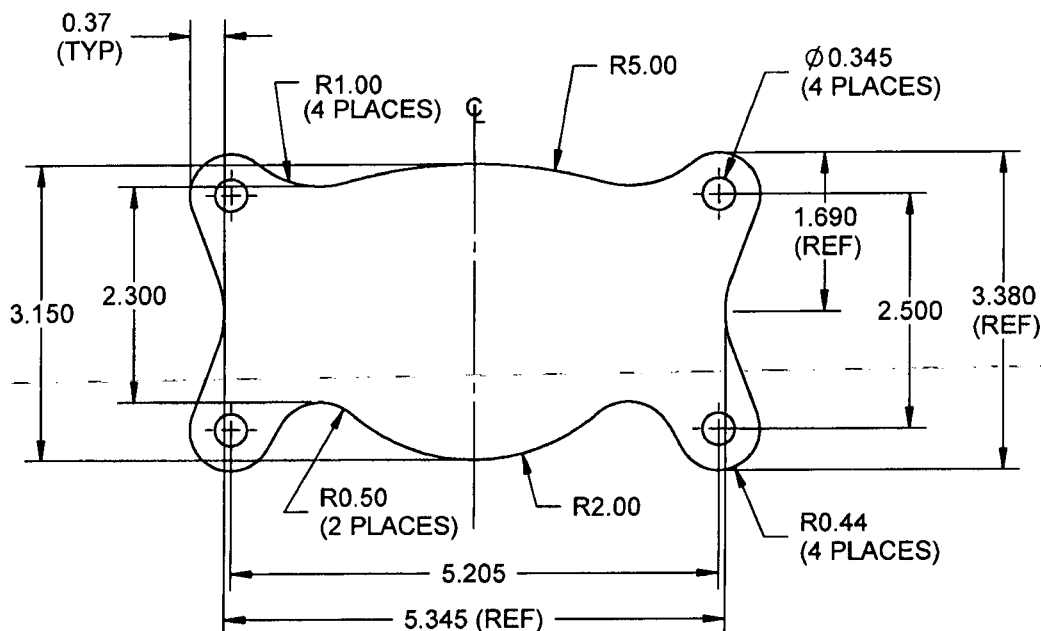
NO. 31382

COPYRIGHT © 2001 BY DART AEROSPACE LTD

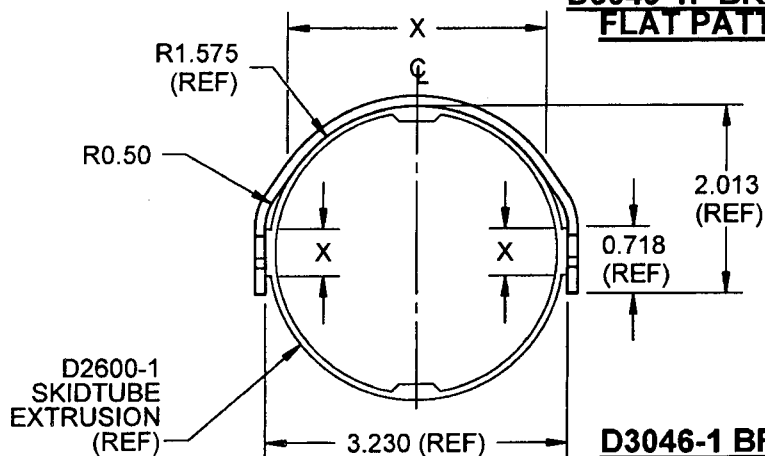
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

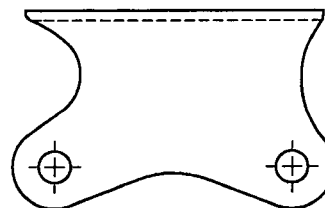
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 2 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 1:2



**D3046-1F BRACKET
FLAT PATTERN**



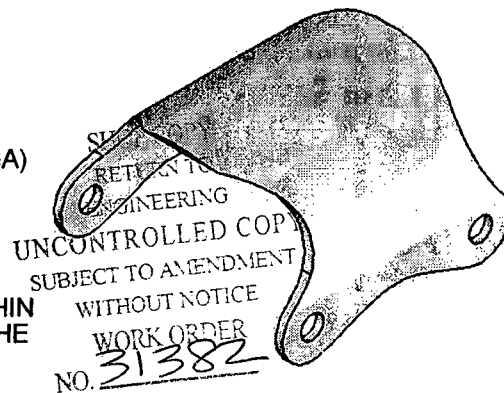
**D3046-1 BRACKET
BEND DETAIL**

**RELEASED**

06/11/13

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK
(12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31382

COPYRIGHT © 2001 BY DART AEROSPACE LTD

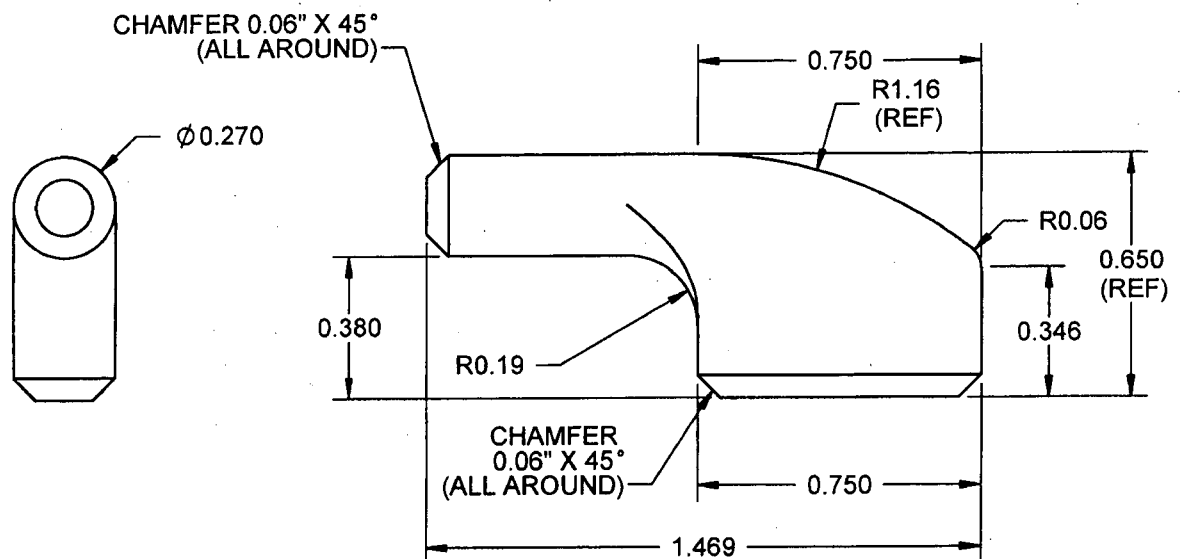
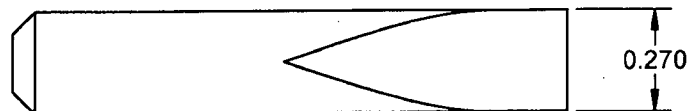
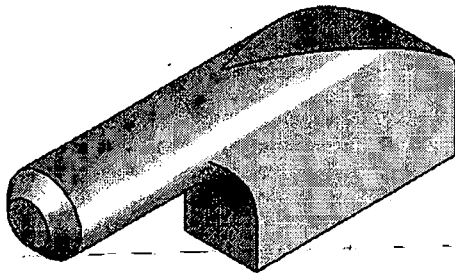
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY	SCALE 2:1

RELEASED

06.11.13



D3046-5 HOOK

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643
(REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUB IT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31382

COPYRIGHT © 2001 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

